

Date: Monday, 12/01/2009 2:30:18 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BACK FRAME ASSEMBLY
Job Number :	44558		
Estimate Number :	11129		
P.O. Number :		Part Number :	D3017041 <i>GY</i>
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3017 REV A
First Issue :	//	Project Number :	N/A
Previous Run :	43601	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	<i>JUD 09/11/09</i>	Due Date :	30/01/2009
Comment :	Est. A 01.09.19 New issue EC	Qty:	1
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 RD Tube .750 x.049W
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Comment: Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s)

4130 Tube .750 OD x.049W

Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall

Batch: *M110740* 30" M11105

EL 9-7-1

2.0	D30177	Lug
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Lug

Pick:

Qty	Part Number	Description	Batch
3	D3017-7	Lug	<i>B38567</i>

EL 9-7-1

3.0	D301711	cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

cap

batch: *B44779*

EL 9-7-1

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3017

2-Bend tube as per dwg D3017

3-Drill holes in D3017-5 Using DT8622

4-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:30:19 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK FRAME ASSEMBLY

Job Number: 44558

Part Number: D3017041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

A/R 4130 Rod Batch: M49317

6-Drill holes in back frame using back panel drill jig DT8621

EL 9-7-1

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

JD 09-07-01

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/07/02 @

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 7:30AM

OVEN TEMPERATURE: 320°C

FINISH TIME: 8:00AM

JD 09-07-06 (1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JD 09-07-06

(K)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

JD 09-07-06

SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/07/07

Job Completion



W 09-07-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

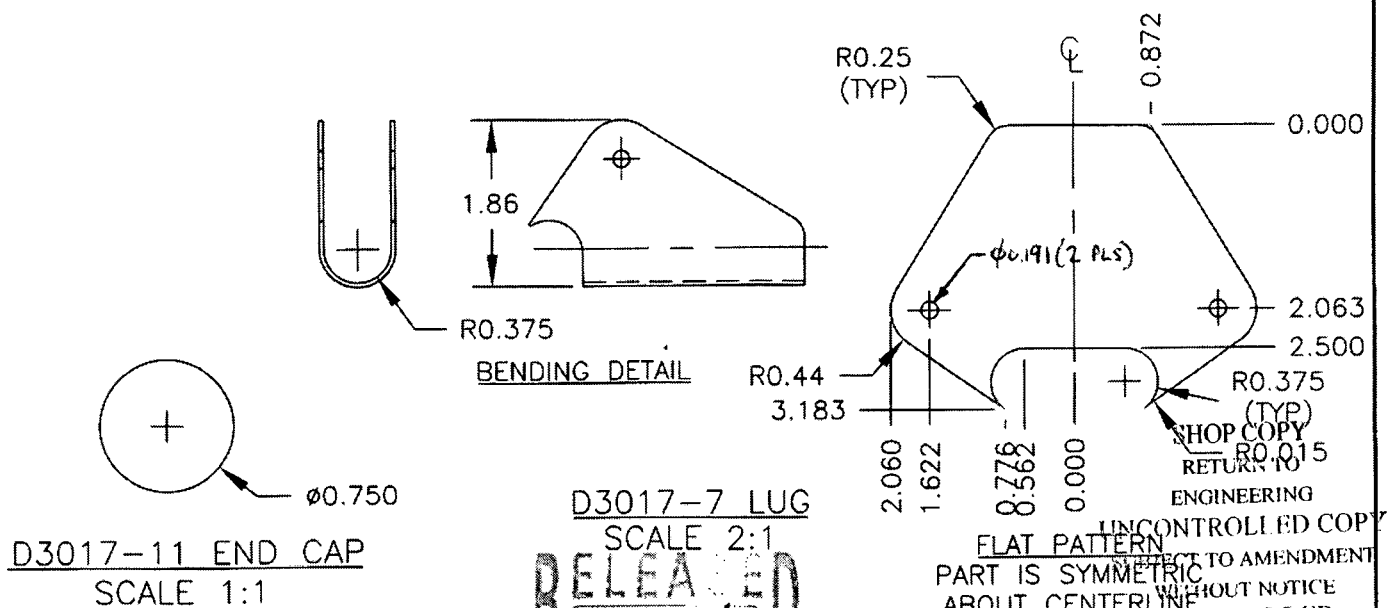


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

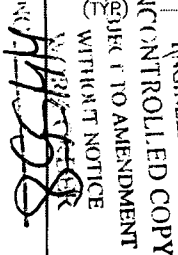
NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.




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D3017-041 BACK FRAME ASSEMBLY
(D3017-1 TUBE, D3017-5 TUBE)

DESIGN	DRAWN BY	 DART AEROSPACE LTD. HARRISBURG, INDIANAPOLIS, INDIANA	
CHECKED	APPROVED		DRAWING NO.
		D3017	SHEET 2 OF 2
DATE		TITLE	SCALE
01.05.18		BACK FRAME ASSEMBLY	1:4